

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021220**Date Inspected:** 30-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint #016 located on 13AE, SEG3007AD as per the weld repair report # B-WR20210.

Welder is identified as 037743. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Repair welding of a weld joint #179 located on 14E, SEG3019D-1 as per the critical weld repair report #

B-CWR2745. Welder is identified as 044772. ZPMC Quality Control (QC) Inspector is identified as Guo Xing

Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G

(3F)-FCM-Repair-1. (See attached photo)

Repair welding of a weld joint #028 located on 13AE, SEG3007AD as per the weld repair report # B-WR20210.

Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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Repair welding of a weld joint #041 located on 13AE, SEG3007AD as per the weld repair report # B-WR20210. Welder is identified as 037743. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Flux Cored Arc Welding (FCAW):

Repair welding of a weld joint #193 located on 13AE, SEG3007Q as per the weld repair report # B-WR20187. Welder is identified as 050242. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-ESAB-Repair.

Repair welding of a weld joint #126 located on 13AE, SEG3007L as per the weld repair report # B-WR19474. Welder is identified as 044795. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-ESAB-FCM-Repair.

Weld joint #003 located on 14E, SEG3019U. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Repair welding of a weld joint #196 located on 13AE, SEG3007Q as per the weld repair report # B-WR20187. Welder is identified as 050242. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-ESAB-Repair.

Weld joint #091 located on 14E, anchor plate to vertical shear plate, SEG3019BB. Welder is identified as 067079. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #003 located on 14E, SEG3019U. Welder is identified as 066418. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Repair welding of a weld joint #199 located on 13AE, SEG3007Q as per the weld repair report # B-WR20187. Welder is identified as 050242. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-ESAB-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Kumar,Sandeep | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
